

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63967

Monday, November 22, 2010 10:30:12 AM



Page 2

Item ID: D3578-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 11/22/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

0.00

Memo

0.00

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

EP 10/11/30 50

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 10/11/30

count

(12)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

=> 10/11/30

30

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Work Order ID 63967

Monday, November 22, 2010 10:30:12 AM



Page 3

Item ID:	D3578-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	11/22/2010	Start Qty:	40.00			
Required Date:	11/30/2010	Req'd Qty:	40.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				30		BR 10-11-30	
170 	Small Fab	0.00							
Small Fab Small Fab	Memo 1-Assemble as per dwg D3578	0.00							
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

Handwritten signature 10/12/01 (50)

Count
(XY)

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Work Order ID 63967

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Monday, November 22, 2010 10:30:12 AM

Item ID: D3578-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 11/22/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Identify as per dwg & Stock Location **2470**

0.00

Memo

0.00

Packaging

11/12/01 (50)

200



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/12/01 (50)**BS 10-12-1 (50)**

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Picklist Print

Monday, November 22, 2010 10:30:15 AM

Page 1

Work Order ID: 63967

Parent Item: D3578-041

Parent Item Name: Doubler



Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A07.04.11 New issue EC
IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 Rivet		Purchased	No			110	Each	4,011.000	2	80			
<div> <div>Location</div> <div>ST316</div> <div>19099</div> </div> <div> <div>Loc Qty</div> <div>4011</div> <div>4011</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			170	sf	7.8150	0.007	0.294737	.4		
<div> <div>Location</div> <div>MAT</div> <div>115689</div> </div> <div> <div>Loc Qty</div> <div>7.815</div> <div>7.815</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
MS21075L3 Nutplate		Purchased	No			170	Each	39.0000	1	40			
<div> <div>Location</div> <div>ST303</div> <div>113734</div> <div>ST350</div> <div>115908</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> <div>38</div> <div>38</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													

EP 10/11/30

100

KB10-11-24

50

116684

EP 10/11/30

M116242 (29x)

21

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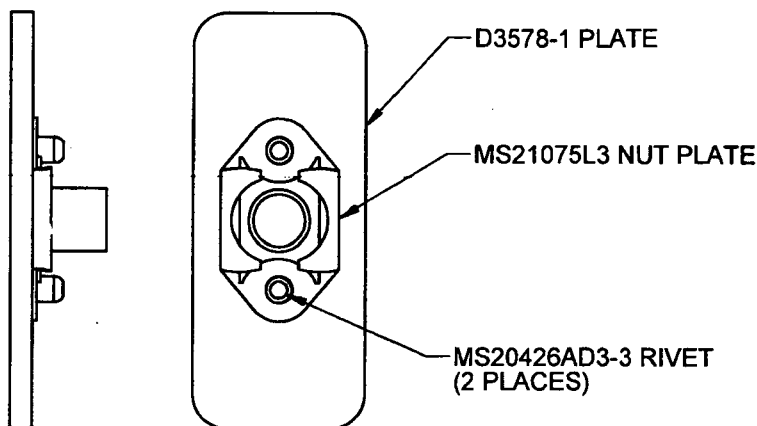
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

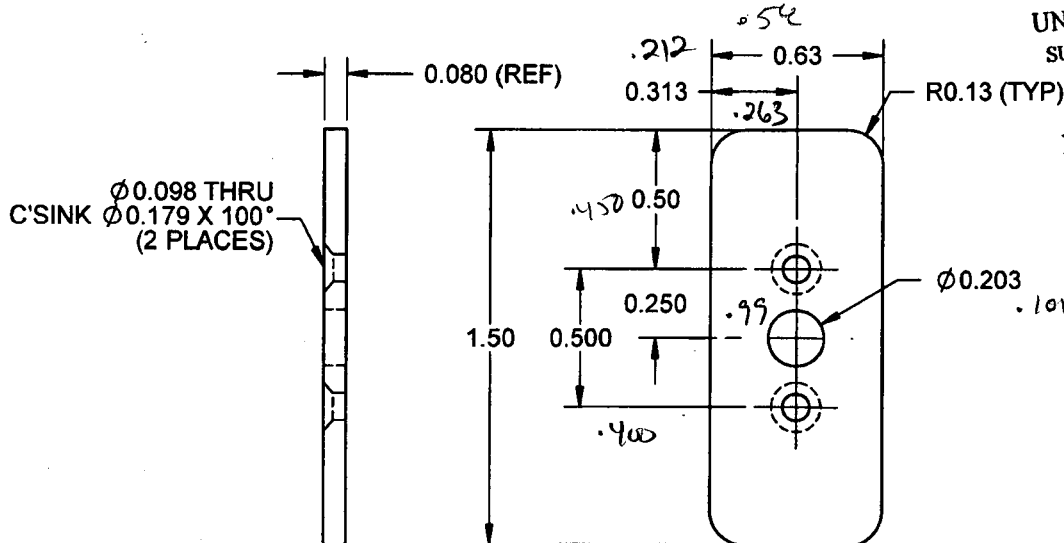
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>HA</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12	TITLE DOUBLER		SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

**RELEASED**
07.04.02 #**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER**D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43967*
2/10/11-22**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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